

Date: Tuesday, 11/29/2005 6:47:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 25033		
Estimate Number	: 10437		
P.O. Number	: N/A	Part Number	: D33191
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D3319 REV: B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: SEE ABOVE USER & DATE	Due Date	: 12/21/2005 Qty: 20 Um: Each
Checked & Approved By	: EST REV B 05-10-14 KS/RC		
Comment	: Created By Auto Work Order		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000186 05/11/30

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3319

Possible Supplier: Industrial Laser

Material release note is required

Tools:

2.0 D33191F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

WEARPLATE

Tools:

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

DL 05/12/30 20

Tools:

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

N/A

Tools:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: *B*
2- Form flat on press using DT8776 block

SB 06/01/05

Tools:

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J-06-01-05

Tools:

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: *B*
Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod *M19682*

(21)

CPL 06-02-16

Tools:

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1A 06/02/16 21

Tools:

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

q.m 06-03-10

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MM

06 03 13

(21)

Tools:

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 51361

PW

4/3/13

(21)

Tools:

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

DD

06 03 14

(21)

Job Completion



u

06.03.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(08) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5003/21329

CUSTOMER	Wilkinson	P41007DI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC107797																		
CUSTOMER O/N	90-21N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																		
MILL O/N	453666		DIMENSIONS	0.044" x 48" x Coil	DATE	31 March 2005																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE	BEND	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)
		x100				x1000										x10000	x100	180°						
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1729
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1296
R9-455951-00	638405	5	1	20	13	19	12	19	17	1	5	1	1					Good				49		2064
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1926
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1978
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1926
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1978

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 x So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=0 (C)=45 (B)=90 (D)=(r0+r80+2r45)/4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x 10mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC METALLURGIST

18 ya CRMS

PO #186

LLMD014-2 T M INDUSTRIAL (P41007DI002.636939)